

Work Order ID 84952-2

May-29-12 1:14:47 PM

\*84952\*

Page 1

Item ID: D2855

Accept

\*N9000040100\*

Revision ID:

Item Name: Cap

Start Date: 29/05/2012 Start Qty: 50.00

Required Date: 16/07/2012 Req'd Qty: 50.00

Reference:

Approvals: Process Plan: MJS

QC:

Date: 12/05/30 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

\*NR1\*

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D2855

Rev B

100

0.00

\*100\*

Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 17002 Cast per Dwg D2855 Material Release Note Required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

\*110\*

Packaging

Packaging

Memo

0.00

Ensure Material Release Note is attached

120

QC6- Inspect dimensions to drawing

0.00

\*120\*

QC

Quality Control

Memo

0.00

100

12-05-30

12/5/12 (100)

100

12-05-30



# Work Order ID 84952

May-29-12 1:14:47 PM

\*84952\*

Page 2

Item ID: D2855

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Cap

Start Date: 29/05/2012 Start Qty: 50.00

\*50\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 50.00

\*50\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

\*130\*

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Drill as per Dwg D2855 using DT82352- Open holes to 19/64"3- Deburr

20x  $\phi$  Ae  
12.07.09  
FF

140

\*140\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Size 109

F10

150

\*150\*

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320°F

11:20

11:50

20x  $\phi$  m/f  
12/07/09

m121841





# Work Order ID 84952

May-29-12 1:14:47 PM

\*84952\*

Page 3

Item ID: D2855

Revision ID:

Item Name: Cap

Start Date: 29/05/2012 Start Qty: 50.00

Required Date: 16/07/2012 Req'd Qty: 50.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC3- Inspect Part Finish

0.00

\*160\*

QC

Memo

0.00

Quality Control

20x 6 M12x7log

170

Small Fab

0.00

\*170\*

Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

20x 4 M12x7log

180

QC5- Inspect part completeness to step on W/O

0.00

\*180\*

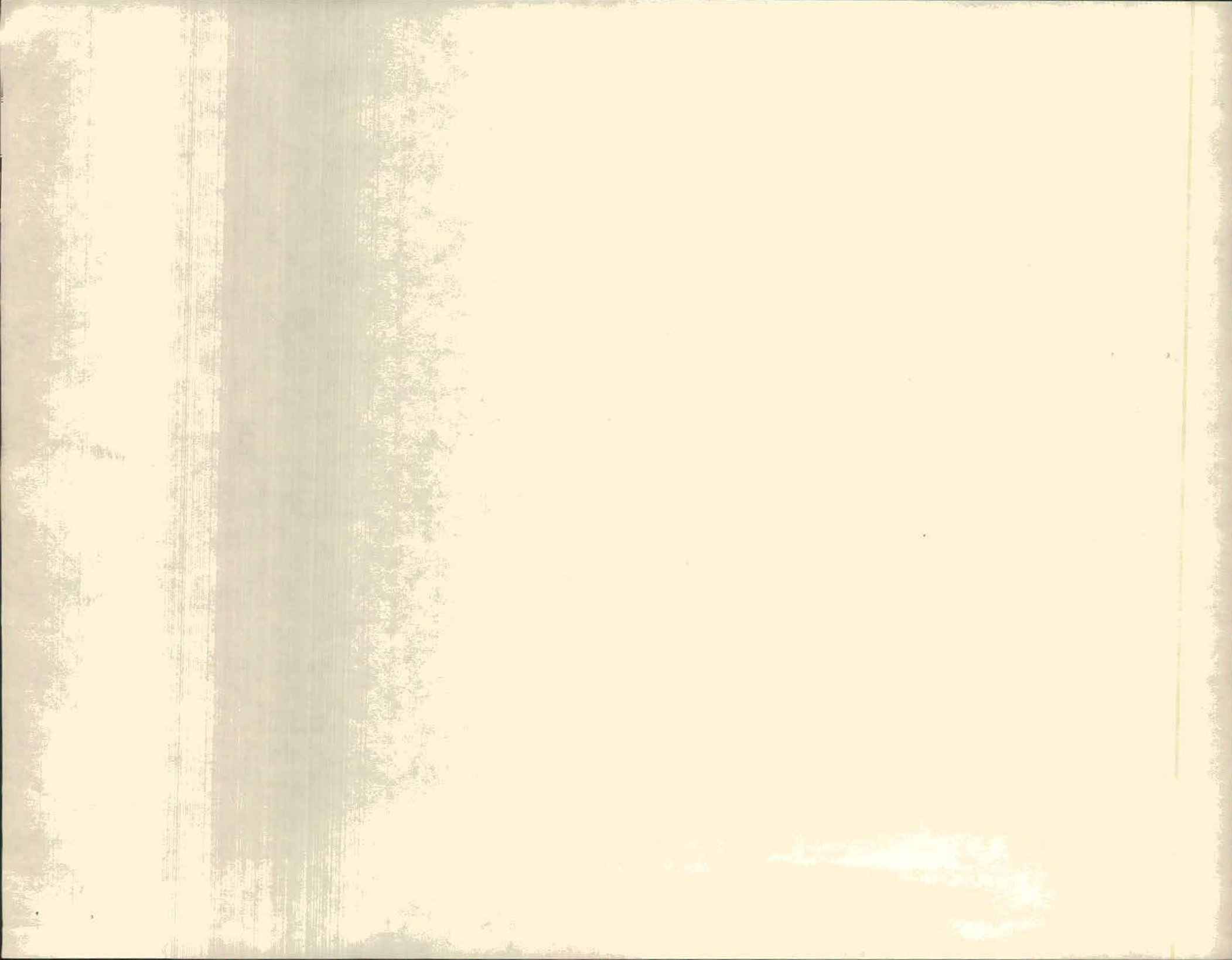
QC

Memo

0.00

Quality Control

20x 6 M12-7-9



# Work Order ID 84952

May-29-12 1:14:47 PM

\*84952\*

Page 4

Item ID: D2855

Revision ID:

Item Name: Cap

Start Date: 29/05/2012 Start Qty: 50.00

Required Date: 16/07/2012 Req'd Qty: 50.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

Identify as per dwg & Stock Location: F2-1

0.00

\*190\*

Packaging

Memo

0.00

Packaging

x20 4 12/10/09

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

QC

Memo

0.00

Quality Control

OK 12/7/10

MF  
12-07-09







# Picklist Print

May-29-12 1:14:51 PM

Page 1

Work Order ID: 84952

Parent Item: D2855

Parent Item Name: Cap

\*84952\*

\*D2855\*

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B00.06.22Added receiving step & removed P/O for powder coat  
EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-225

Purchased

No

100

Each

1,075,000

2

100

\*AI S7-1032-225\*

✓ ALS4-1032-225 / 122240

\*\*  
x40

200

22 11/07/09

INSERT

Location

Loc Qty

Loc Code

ST282

1075

100896

135

111529

27

118520

913

D2855P

Purchased

No

170

Each

0.0000

1

50

\*D2855P\*

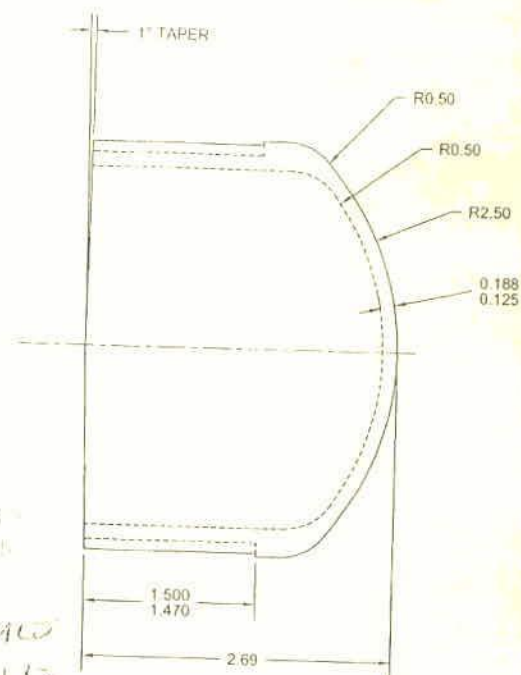
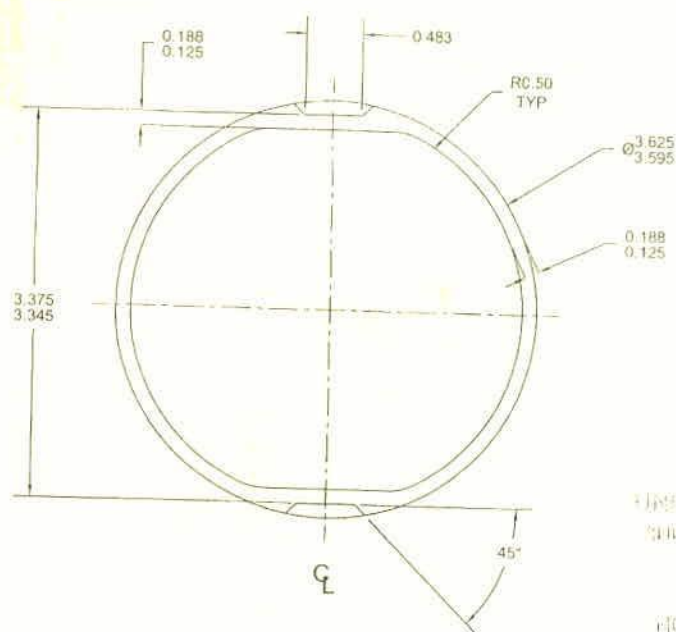
\*\*

100

Cap

*12/2/12 (100)*





DART AEROSPACE LTD.  
 1000 DART ROAD  
 HAWKESBURY, ONTARIO, CANADA  
 K6H 1P4  
 TEL: 849-22-1100  
 FAX: 849-22-1101  
 12/08/30

# D2855C CASTING DETAIL B

## NOTES:

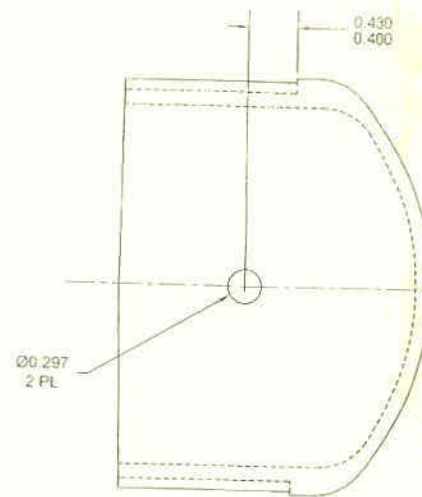
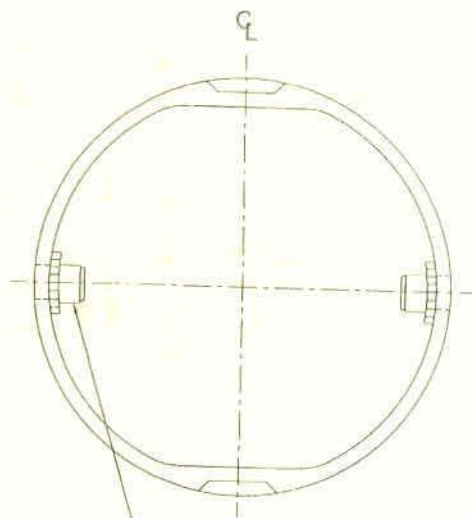
- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

RELEASED  
 09/07/15

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR	<i>RF</i>	D2855	SHEET 1 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR	<i>RF</i>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE REPRODUCED OR USED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	







INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
2 PL

# **D2855 CAP** (MAKE FROM D2855C CASTING)

**RELEASED**  
9/6/19

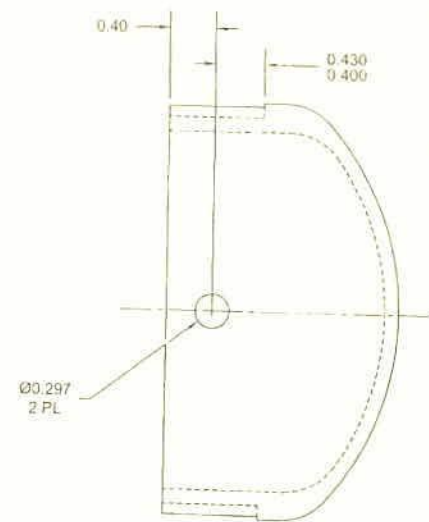
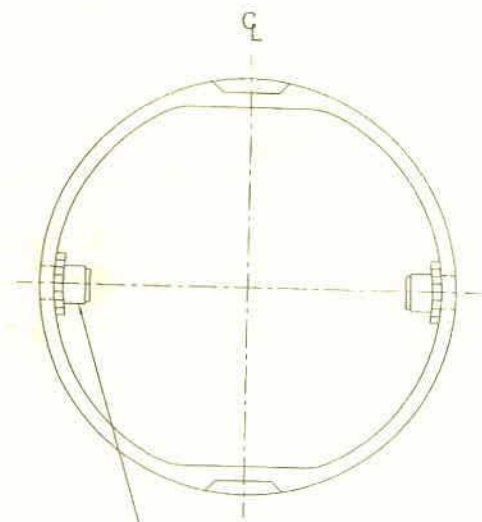
## **NOTES:**

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	EP	D2855	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	H	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND IS NOT TO BE RELEASED OR SUPPLIED TO THE PUBLIC OR ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD</small>	



8-1952



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
2 PL

**D2855-3 CAP**   
(MAKE FROM D2855C CASTING)

**RELEASED**  
*09/17/15 MB*

**NOTES:**

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR	<i>RF</i>	D2855	SHEET 3 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR	<i>RF</i>	CAP	NTS
DATE	09.06.30	<small>COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS ISSUED. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	







Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO17082

Purchase Order Date 5/30/12

PO Print Date 5/31/12

Page Number 1 of 1

Order #

VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.  
2225 CHEMIN ST. FRANCOIS  
DORVAL, QC H9P 1K3  
CA

Contact Name

Buyer

Brigitte Golden

Vendor Phone

514 683 9777

Requisition Nbr

Vendor Fax

514 683 0375

Tax Resale Nbr

10127-2607

Vendor Account Nbr

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D2855P	Cap	6/08/12 Yes	100.00 Each	Yours ppd	\$18.7000	\$1,870.00

Special Inst: As per DWG: D2855  
Rev: B  
B84952

PO Total: \$1,870.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

No substitution or deviation without  
consent.

Certificate of Conformity or Material  
Certification required - (YES) NO

Change Date: 5/31/12

Change Date: 5/31/12



# Aluminum Foundry Ltd

2215 Chemin St. Francois  
Dartmouth, Québec H9P 1K3  
Tel: (418) 683-9777  
Fax: (418) 683-0375  
Email: info@foundryafpw.com

## Packing Slip

Packing Slip No.: 34078  
Shipped Date: 14 06 2012

<b>Sold to:</b>	<b>Ship to:</b>
<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7  Tel. (613) 632-5200 Fax (613) 632-5246	<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
<b>Order No.:</b> 17082	
<b>Shipped By:</b> Fedex	
<b>Tracking No.:</b>	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV A	100
<div>Received by:</div> <div>Date:</div>			

Comment:





CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

2225 Chemin St. Francois, DORVAL, QC H9P-1K3  
TEL : (514) 683-9777 FAX: (514) 683-0375

Expédié à  
Shipped

**DART AEROSPACE**

A.F. & P.W.Série no./Serial no.

**1270 Aberdeen Street**

Date: **14/06/2011** Packing Slip No. **34078**

**Hawksbury, ON, K6A 1K7**

Votre No. Commande **17082**  
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificates di détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
100pcs	D 2855 CAP	Z098046	A356.2	B#1215801

Analyse  
Analysis (as in ingot C626-1019)

(Si)	7.10%	(Al)	balance
(Fe)	0.10%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.38%		
(Zn)	<0.01%		
(Ti)	0.12%		

Donne  
Yield :

Résistance a la tension :  
Tensile Strength :

Allongement par pouce carré :  
P.S.I. Elongation :

%

Pour et au nom de  
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :  
Par/Per :

Coc-100

